

March 3

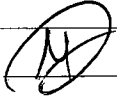
Work Order ID 130236

130236

Page 1

Friday, February 27, 2015 4:18:53 PM

Item ID: D3935-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pylon Wall Protector, LH
 Start Date: 2/26/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/03/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan:  Date: 5.2.27 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3935	B								

100 0.00
100 2 0 Jm15-3-2
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3935
 F60029-04 Dwg Rev: B
 Prog Rev: B
 2- Deburr if necessary

110 0.00
110 2 0 Jm15-3-2
 QC Memo 0.00
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130236

Friday, February 27, 2015 4:18:53 PM

130236

Page 2

Item ID: D3935-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pylon Wall Protector, LH

Start Date: 2/26/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/03/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

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Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(2)

38
9-89

MAR 03 2015

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

DAS
06
9-89

MAR 02 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MUD 15-03-03

(15-3-3)

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Picklist Print

Page 1

Friday, February 27, 2015 4:18:53 PM

Work Order ID: 130236

130236

Parent Item: D3935-1

D3935-1

Parent Item Name: Pylon Wall Protector, LH

Start Date: 2/26/15

Required Date: 3/03/15

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased				100	sf	1,134.134	8.69	21			

MI FXS 125-F60029-04

Jm15-3-2.

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT019

1134.1344

m129759

110.3334

m130209

1023.801

130209

DQA: _____ Date: _____



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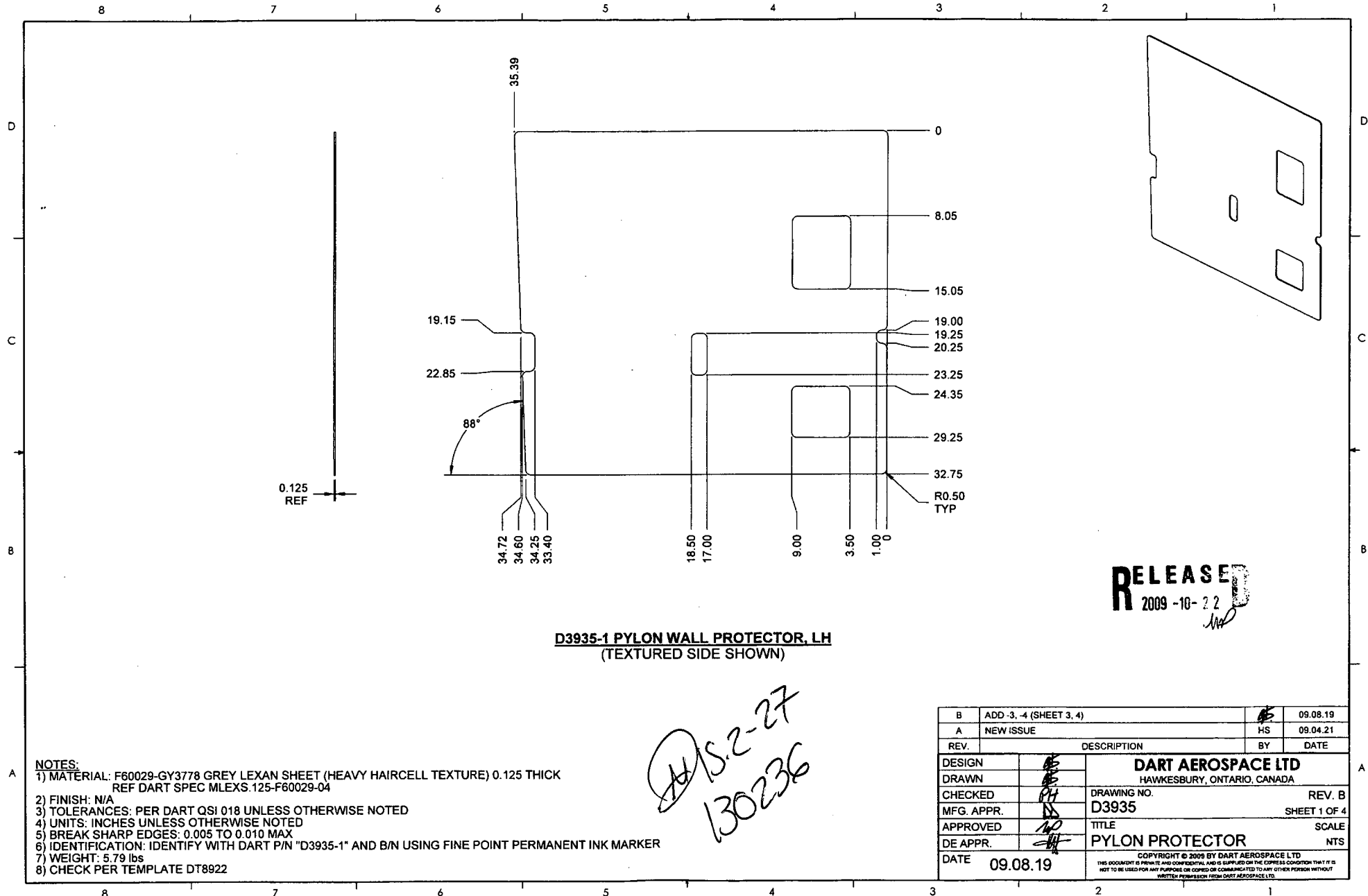
DART AEROSPACE LTD		Work Order:	190236
Description: Pylon Wall Protector, LH		Part Number:	D3935-1
Inspection Dwg: D3935	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.05	+/-0.030	8.05	-		U	Jkmo1
15.05	+/-0.030	15.05	-		T	Jkmo7
19.00	+/-0.030	19.00	-		T	
19.25	+/-0.030	19.25	-		T	
20.25	+/-0.030	20.25	-		T	
23.25	+/-0.030	23.25	-		T	
24.35	+/-0.030	24.35	-		T	
29.25	+/-0.030	29.25	-		T	
32.75	+/-0.030	32.75	-		T	
1.00	+/-0.030	1.00	-		U	
3.50	+/-0.030	3.50	-		V	
9.00	+/-0.030	9.00	-		T	
17.00	+/-0.030	17.00	-		T	
18.50	+/-0.030	18.50	-		T	
33.40	+/-0.030	33.40	-		T	
34.25	+/-0.030	34.25	-		T	
34.60	+/-0.030	34.60	-		T	
34.72	+/-0.030	34.72	-		T	
22.85	+/-0.030	22.85	-		T	
19.15	+/-0.030	19.15	-		T	
35.39	+/-0.030	35.39	-		T	
0125	+/-0.010	0.125	-		V	

Measured by:	Jm	Audited by:	DAS 38	Preliminary Approval:	N/A
Date:	15.3.2	Date:	9-80 MAR 03 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	
B	10.08.18	Dwg Rev updated	KJ	



RELEASED
2009-10-22
Handwritten signature

D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

Handwritten: 15.2-27
130236

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

B	ADD -3, -4 (SHEET 3, 4)	HS	09.08.19
A	NEW ISSUE	HS	09.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.08.19		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3935	REV. B
TITLE PYLON PROTECTOR	SHEET 1 OF 4
	SCALE NTS
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